

# ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD					ECN #:
Date: 05.07.22					712
Project No: D412-724		Created By: RF		Checked By: <i>[Signature]</i>	
Project Name: HEAD REST		Approved By: <i>[Signature]</i> (Proj. Manager)		Approved By: <i>[Signature]</i> (Management if reqd) N/A	
Description of Change: RELEASE : D3304 REV. B					
Notification/Acceptance		Affected	Initials	Authorization	
QA		✓	<i>[Signature]</i>	<i>OK per [Signature]</i>	
Production		✓	<i>[Signature]</i>		
Planning		✓			
Marketing		N/A			
Engineering Actions		Yes	No	Responsible	To happen by:
Update Blue/Pink File		✓			
Update DSI File		✓			
Update D-Part Master Binder		✓	KJ	ASAP	05.08.19 <i>[Signature]</i>
Update Grey Project Binder		✓			
Update DEO Binder		✓			
Update Master Document List		✓			
Update Drawing Approval Record		✓	KJ	ASAP	05.08.11 <i>[Signature]</i>
Update Change Record Form		✓			
Move Electronic File		✓	KJ	ASAP	05.08.19 <i>[Signature]</i>
Notify TCA of Change		✓	DS	ASAP	05.08.11 <i>[Signature]</i>
Notify FAA of Change		✓			
Update QSI 021		✓			
Update QSI 036		✓			
Scan Documents		✓			
Update MIS Database		✓	KJ	ASAP	05.08.19 <i>[Signature]</i>
Update Access Database		✓	KJ	ASAP	05.08.19 <i>[Signature]</i>
Verification ARC		✓			
Create/Update STC Approval List		✓			
Create/Update IPP's		✓	JLM	ASAP	<i>[Signature] 05.08.17</i>
Create/Update BOM's		✓	JLM	ASAP.	<i>[Signature] 05.08.19 <i>[Signature]</i></i>
Create/Update PPP's		✓			
Update Paperwork Kits in Production		✓			
Update Paperwork Kits in Stock		✓			
Rework/Scrap Current Production		✓			
Rework/Scrap Kits in Stock?		✓			
Create/Update Laminated Dwgs		✓			
Create/Update Controlled Dwgs		✓	KJ	ASAP.	05.08.19 <i>[Signature]</i>
Create/Update FAI sheets		✓			
Create/Update CNC Programs		✓			
Create/Update Tooling		✓	DAN	ASAP	N/A <i>[Signature] 05.09.12</i>
Create/Update DXF File		✓	RF	ASAP.	<i>[Signature] 05.07.22</i>
MPP required?		✓			
Notify Previous Customers		✓			
Notify Eurocopter France		✓			
Notes:					
<ul style="list-style-type: none"> <li>- ENSURE WELDING TOOL WORK PROPERLY AS PER REV. B</li> <li>- CREATE IPP'S &amp; BOM FOR D3304-7/-8 done</li> <li>- UPDATE IPP'S &amp; BOM FOR D3304-043/-044 AS PER REV. B. done</li> <li>- DXF ALREADY IN DXF FILE.</li> <li>- TOOLING IS NOT REQ'D. BECAUSE NOW IS D3304-7/-8 BRACKET <i>[Signature] 05.09.12</i></li> </ul>					

M 16258  
REFERENCE ONLY

DART AEROSPACE LTD	Work Order:	
Description: Tube Assembly	Part Number:	D3304-043
Dwg: D3304 Rev. A1	Qty:	
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	MC	Cut blank: 22.00" as per Dwg D3304 Material: AISI 304/316 SS tubing 0.875" x 0.065" wall (M304TR0.875W.065) <b>Identify for D3304-3</b> Batch: _____			
3	MC	Turn as per Folio FA458 and Dwg D3304 <b>Identify as D3304-3</b>			
4	QC2	Inspect parts as they come off the CNC machine			
5	QC8	Second check			
6	MC	Deburr			
7	GA	Form as per Dwg D3304 <b>Ensure that bend radius does not fall into straight section using DT8756.</b>			
8	GA	Drill as per Dwg D3304 using drill Jig D3304-T1			
9	GA	Cut tube to length as per Dwg D3304			
10A	GA	Deburr			
10B	QCS	<b>INSPECT WORK TO STEP 10A</b>			
11	WS	Weld bracket as per Dwg D3304 and QSI 004 using DT8775 <b>Pick:</b> <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u>			
		1            D3304-57            Bracket            _____			
12	QC9	Inspect weld			
13	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3			
14	QC3	Inspect Powder Coat			
15	GA	Assemble lanyard and pip pin as per Dwg D3304 <b>Pick:</b> <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u>			
		1            BLBS-0016            Pip Pin            _____			
		2            CBL-460            Loop Sleeve            _____			
		12.5"      CBL-1240            Cable            _____			
16	QC5	Inspect work to Step 15			
17	ST	Identify parts with batch number and part number using a fine point permanent marker as per Dwg D3304 and Stock			
18	AC	Cost / part: _____			
19	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.09.08	New issue	KJ/JLM	
B	04.09.28	BLBS-0016 changed from BLRS-001	KJ/JLM	
C	04.11.17	Revised Step 15	KJ/JLM	
D	04.11.26	Revised Steps 7	KJ/JLM	

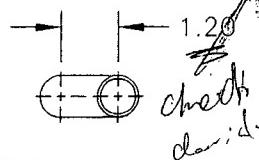
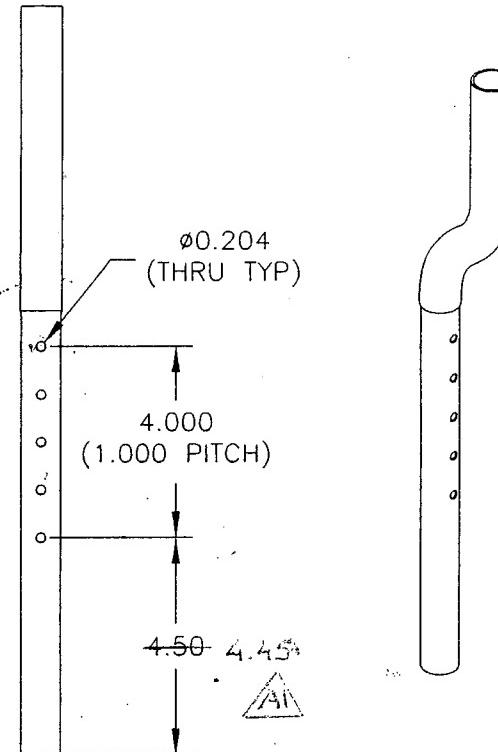
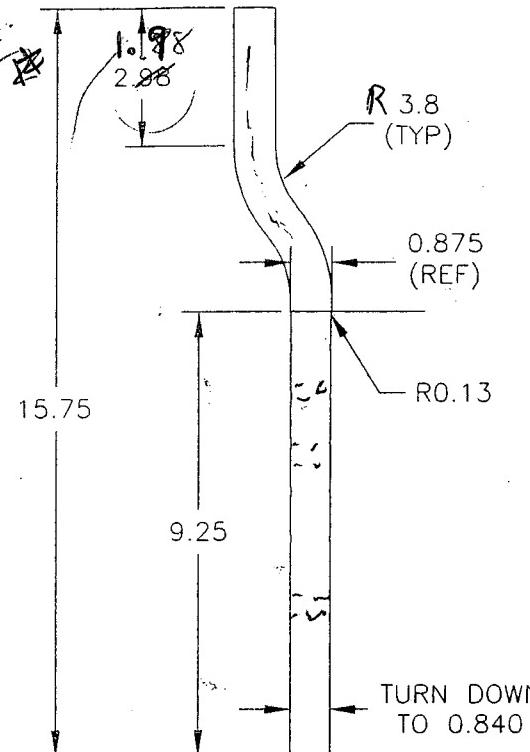
RELEASED  
07.11.29

CONTROLLED COPY



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. A SHEET 3 OF 4
DATE 04.08.18		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED  
04.09.29 CP



Bend lines  
9 $\frac{5}{8}$ , 13 $\frac{3}{8}$

REFERENCE ONLY

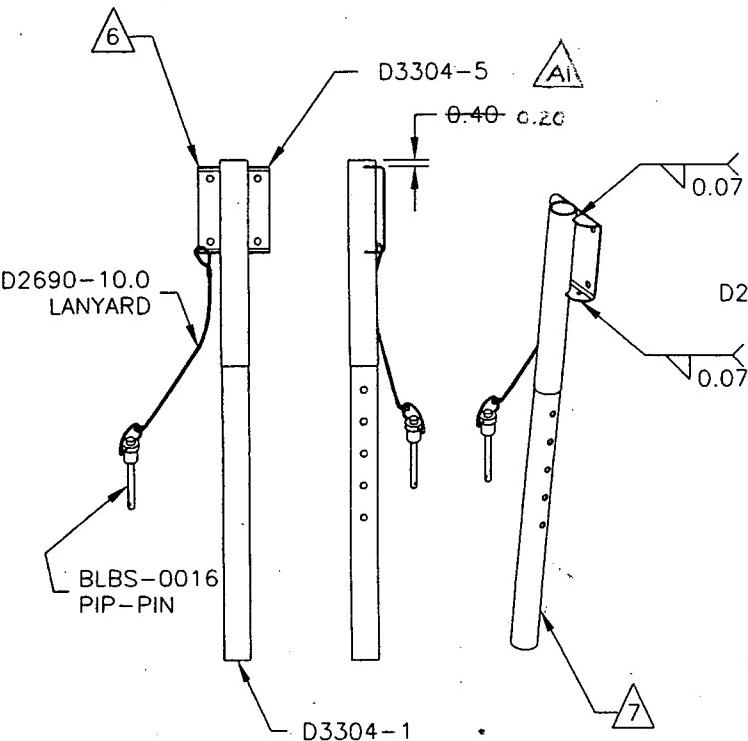
D3304-3 TUBE

Total length 16 $\frac{1}{8}$

D3304-3 NOTES:

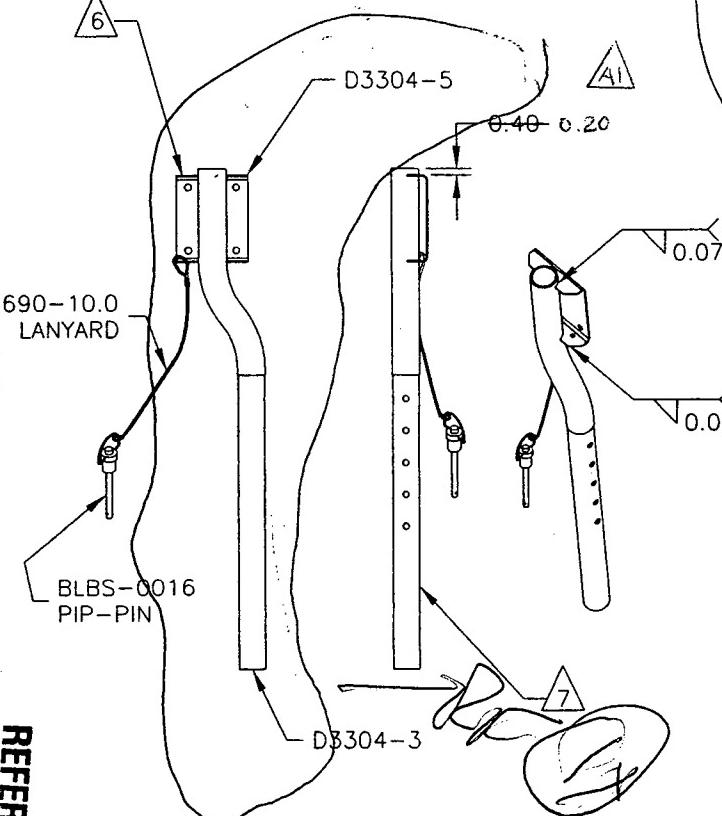
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\varnothing 0.875 \times 0.065$  WALL  
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

Zeile 100  
Durchschnitt  
- 333 -  
1000



D3304-041 TUBE ASSEMBLY

REFERENCE ONLY



D3304-044 TUBE ASSEMBLY (SHOWN)  
D3304-043 OPPOSITE

UNDER REVIEW  
05.06.09 RY

CHECK WITH  
ROBERTO

- D3304-041/-043/-044 NOTES:
- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005
  - 2) WELD PER DART QSI 004
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
  - 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRC  
ELIGIBILITY SEE PDA04-11"
  - 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT  
PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N  
BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	REV. A
DATE 04.08.18	DRAWING NO. D3304		SHEET 1 OF 4
A AI 04.11.23	04.08.18 04.11.23	NEW ISSUE 0.20 WAS 0.40; 4.45 WAS 4.50	SCALE 1:6

**Linda Lacelle**

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**From:** "Roberto Fuentes" <robertof@dartaero.com>  
**To:** "Linda Lacelle" <lindal@dartaero.com>  
**Sent:** Monday, June 13, 2005 3:48 PM  
**Subject:** Re: p codes

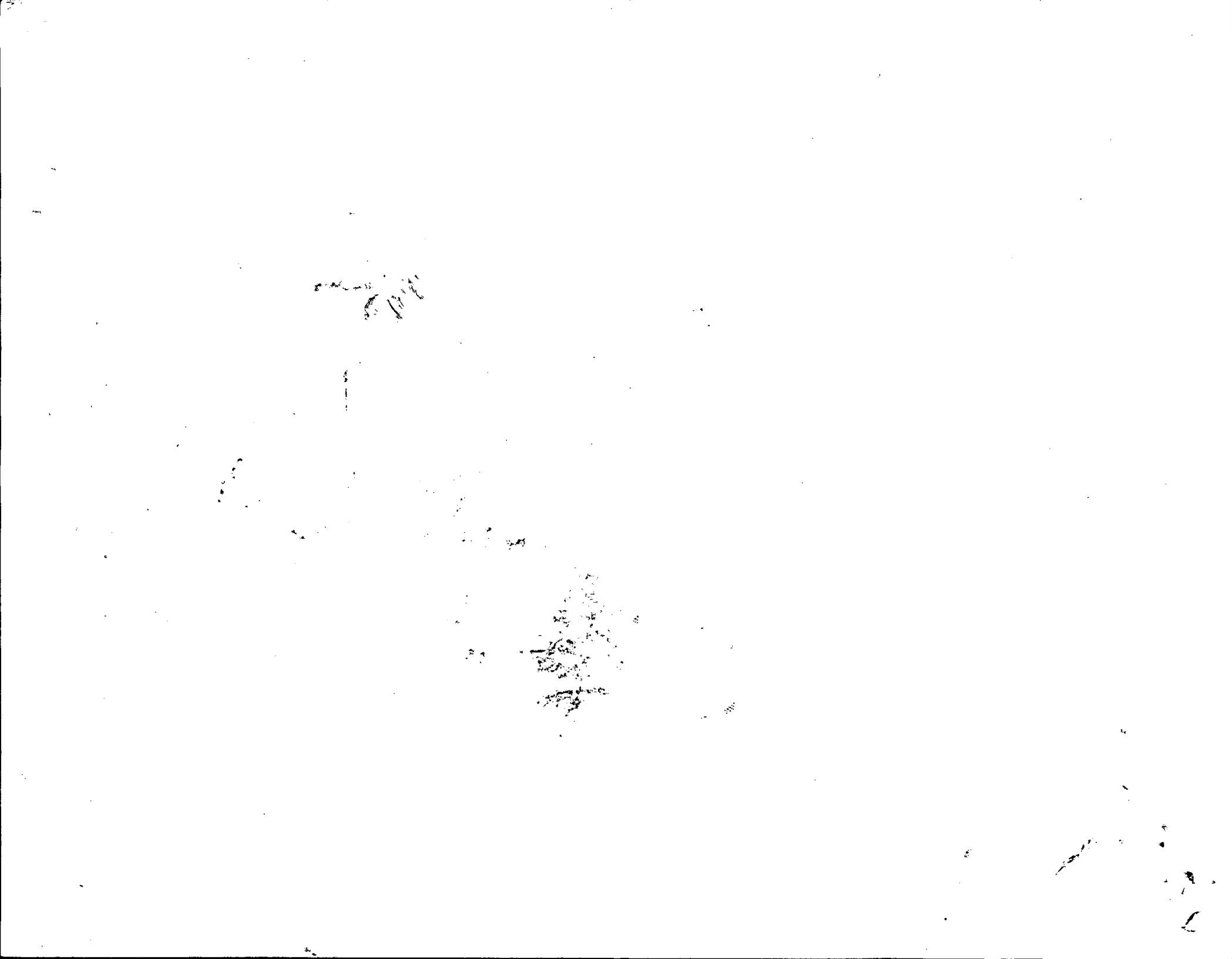
Eurocopter GHW Mod. P601-600  
Tube Headrest P604-561

----- Original Message -----

**From:** Linda Lacelle  
**To:** \*Roberto Fuentes  
**Sent:** Monday, June 13, 2005 2:47 PM  
**Subject:** p codes

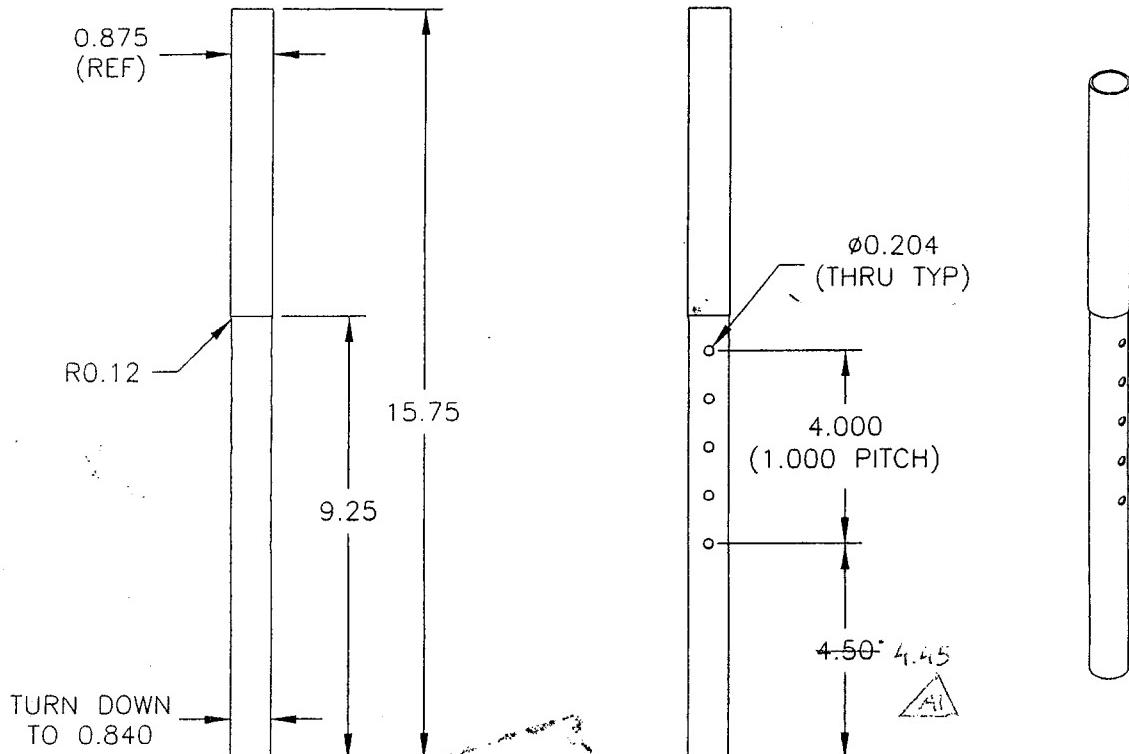
Roberto,  
Do you have P codes for the D2281 jack saddle (grd handling - eurocopter)  
and D3304 tube assembly(headrest)?

Linda





DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3304	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED  
07.09.25 SPD3304-1 TUBE

REFERENCE ONLY

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015